



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2580-1

Job Sheet 171758



Part No: D2580-1

Job Qty: 4 ea

Part Name: 205 Bent Tube



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/8/18

Job Tracking No:

Due Date: 3/2/18

Created By: Michelle Gagnon-Donovan

Type: Stock

Description:

Note: DWG REV 6 SHEETS 1,2,3,8 IPP B 01.11.08 Revised Step 9, 10, 12, and 13 SM IPP Rev:C 10.12.01 as per DEO D1 DD verf:ec

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		3/1/18	0.00	0.00	Start Up Skid tubes		
100	Skid tubes	4 pcs		3/1/18	0.00	3.70	Skid tubes		
101	QC	4 pcs		3/1/18	0.00	0.00	QC6		
110	HandFinish	4 pcs		3/1/18	0.00	1.67	HandFinish1		
120	QC	4 pcs		3/1/18	0.00	0.00	QC7		
125	Skid tubes	4 pcs		3/2/18	0.00	3.70	Skid tubes		
130	QC	4 pcs		3/2/18	0.00	0.00	QC5		
140	Packaging	4 pcs		3/2/18	0.00	0.00	Packaging3		
150	QC21-SA	4 Ea		3/2/18	0.00	0.00	QC21		

Part Op 100 - 1- Inspect mat'l D2500-1-190 for damage. 2-Drill pilot holes using drill jig DT 8149 A-BC-D 3-Open holes to 0.508"
Descriptions: as per Dwg D2580 4-Deburr holes per QSI002 section 4.2.3 and blow out all chips from inside of tube 5- Test fit inspection saddles on FWD & AFT saddle holes using DT9916.
125 - 1- Bond web in place per QSI 015. A/R Sikaflex-291 batch: M138 787 Sikaflex expire date: 2018-04-21 Start time and date: _____ bond for 12hrs
140 - LOCATION : LG002

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2500-1-190	Ext'n -1" Beam Tube 4"	4 Ea (1 ea)	90-Start up Operation	
D2596	Web, 205 Skid tube	4 Ea (1 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2500-1-190	4	115	0
	D2596	4	4	0

Part Specifications

Specifications could not be found.

Plex 2/8/18 10:46 AM Dart.Gagnon.Michelle



Container No: S043143



Part: D2580-1

Job No: 171758

Serial No/Batch: S043143

Revision: D2580

Inspector:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
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www.dartaerospace.com

Date: 02/16/18

ITEM	QTY -041	QTY -043	QTY -047	QTY -048	PART NUMBER	DESCRIPTION
1	X				D2580-041	SKIDTUBE ASSEMBLY
2		X			D2580-045	SKIDTUBE ASSEMBLY
3			X		D2580-047	SKIDTUBE ASSEMBLY
4				X	D2580-049	SKIDTUBE ASSEMBLY
20	1	1	1	1	D2580-1-100	EXTRUSION
21			16	16	D2570	BUSHING
22	1	1	1	1	D2575-3	STEP
23	4				D2578	SPACER
24	16	16	8	8	D2584-1	PLUG
25	16	16	8	8	D2584-3	O-RING
26	1	1	1	1	D2586	205 WEB
27	1	1	1	1	D2585	AFT CAP
28	1	1			D2584-5	WEARSHOE
29	1	1			D2584-9	WEARSHOE
30	1	1			D2584-11	WEARSHOE
31	1	1			D2584-13	WEARSHOE
32	20	20	24	24	D4202-1	SPACER
33			1		D4202-041	WEARPLATE ASSEMBLY
34			1		D4202-043	WEARPLATE ASSEMBLY
35			1		D2581-1	FWD WEARPLATE
36			1		D2581-3	AFT WEARPLATE
50	50	50			ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
51	50	50			ANSCA	BOLT
52	2	2	2	2	ANB-5A	BOLT
53			8	8	ANM-5A	BOLT
54	50	50			NA511480C032R	WASHER (AN880C10L)
55	2	2	2	2	NA511480D032J	WASHER (AN880D10L)
56			8	8	MS21043-4	NUT (OR MS21042-4)

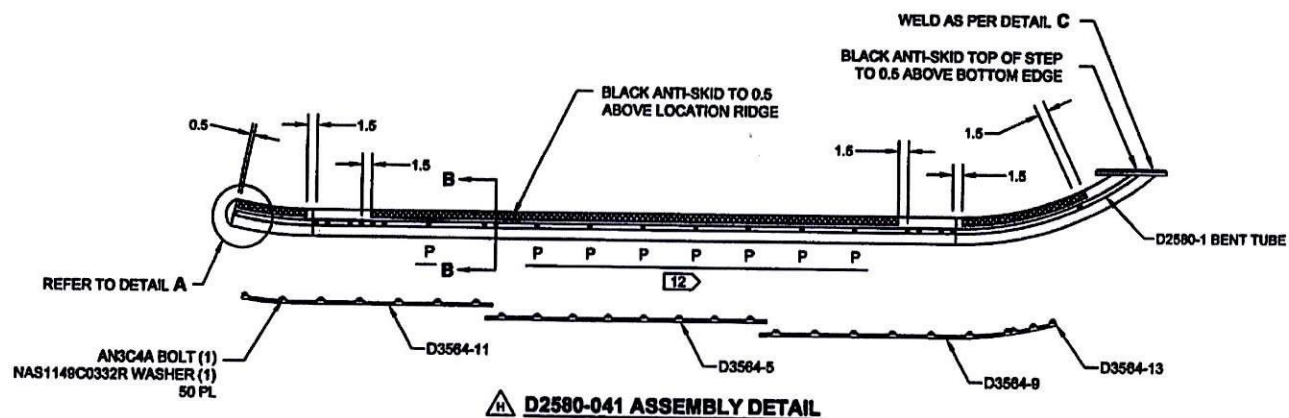
GENERAL NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION PER DART QSI 005 4.1 PRIOR TO INSERTING D2586 WEB POWDER COAT (-041-047-049) GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4.
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D2580-041 = 33.7 lb
D2580-045 = 33.7 lb
D2580-047 = 45.1 lb
D2580-049 = 32.0 lb
- 8) WELDING PER DART QSI 004.
- 9) INSERT D2586 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 10) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 90 AND ALLOWABLE IN THE BEST PORTION OF THE TUBE.
- 11) USE DART DRILL TEMPLATE DTE217 & DTE217 ONLY FOR D2580-041-045 TO LOCATE AND DRILL 20.287 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTIONS B-B AND F-F (50 PLACES) AFTER FINISH. INSTALL ANSCA BOLT 8 AND NA511480C032R WASHERS WITH SIKAFLEX-241-291.
- 12) INSERT D2584-1 PLUG C/W D2584-3 O-RING IN HOLES MARKED "P" (BOTH SIDES OF TUBE) AFTER FINISH (18 PLACES FOR D2580-041-045 AND 8 PLACES FOR D2580-047-049)
- 13) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2585 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

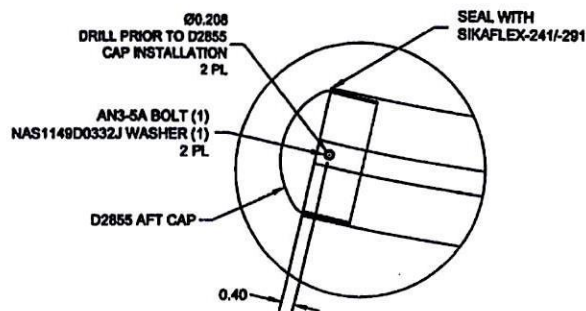
REV.	DESCRIPTION	DATE
H	SHEET 1: PL DELETE D2580-142-13 GASKETS, WEIGHTS UPDATED ACCORDINGLY, SHEETS 2 & 4 PICTORIAL UPDATE FOR REMOVAL OF GASKETS	17.06.09
G	ADDED -048 -047 WEIGHT UPDATED PER DSI 9998	14.04.09
F	INCORPORATE DEO D2580-E-1 PER PART 12-218	13.06.20
E	ADD D2580-047 (ZN CA-7) AND D2580-7 (ZN BS-0); INCLUDED DEO D2580-D-1; REFORMATTED DRAWING TO CURRENT STANDARDS; DTE217 & DTE217 WAS DTE217-208 (ZN CL-1)	11.06.21
D	CHANGE TO S3 WEARPLATES AND GASKETS, INCLUDE DEO 8124/8163	07.04.06
C	REDRAWN, INCLUDED DEO 9094/9097	06.06.20
B	AS MANUFACTURED	06.12.02
A	NEW ISSUE	06.08.16
DESIGN	DS	DATE
DRAWN	SAD	
CHECKED	REV. H	
INFO. APPR.	D2580	SHEET 1 OF 9
APPROVED	TITLE	SCALE
DE APPR.	205 SKIDTUBE ASSEMBLY	NTS
DATE	17.06.09	

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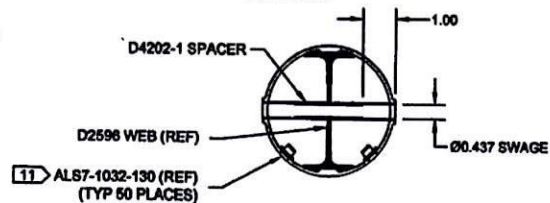
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DETAIL A
SCALE 5X

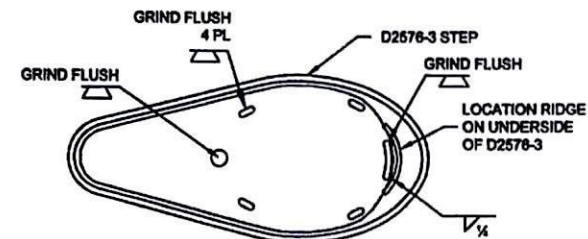


SECTION B-B
SCALE 5X



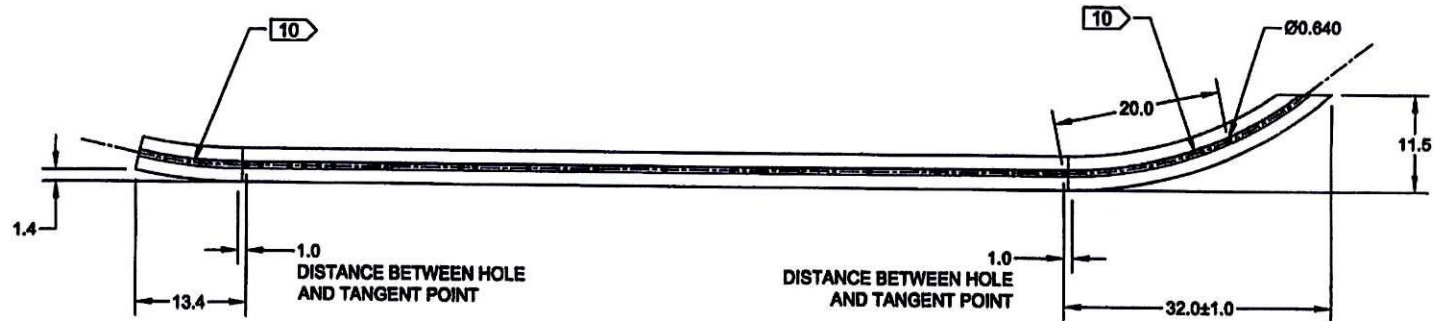
AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:
1. INSERT D4202-1 SPACER (20 PLACES)
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002
3. TRIM / GRIND FLUSH PER QSI 002

DETAIL C
SCALE 5X



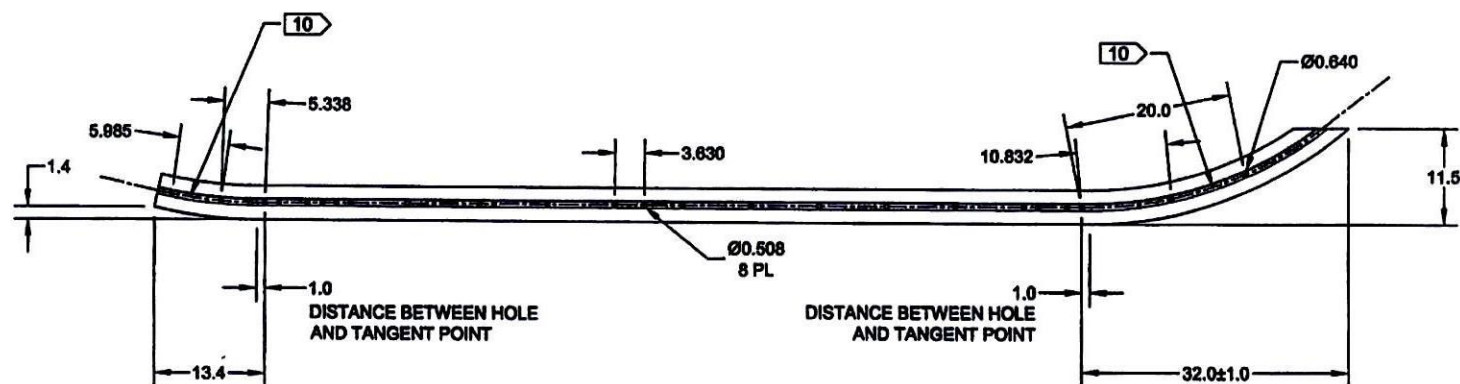
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2017 JUL 05

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MFG. APPR.	<i>[Signature]</i>	D2580	SHEET 2 OF 8
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	205 SKIDTUBE ASSEMBLY	NTS
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APPROVED	<i>[Signature]</i>	TITLE	SCALE
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D2580-7 BENT TUBE
(MAKE FROM D2580-101 TUBE)

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